

Work Order ID 83220-2

April-13-12 1:42:35 PM

\*83220\*

**U/R**

Page 1

Item ID: D4154-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly

Start Date: 13/04/2012 Start Qty: 5.00

\*5\* 2

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/13 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4154

B U/R

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

\*\*DT9756\*\*

2059 B Hardcoat Welding Rod

BATCH#: M122030

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: M120013

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

2x Ø Cpl 12-06-19

12-06-18  
JBL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83220

April-13-12 1:42:35 PM

\*83220\*

Page 2

Item ID: D4154-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly

Start Date: 13/04/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

8/2/02/12

Quality Control

150

0.00

\*150\*

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3  
dwg D4154.

B121960

AB 12-6-21 (2)

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00

Quality Control

2 φ BR 12-6-21.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 83220

April-13-12 1:42:35 PM

\*83220\*

Page 3

Item ID: D4154-041  
Revision ID:  
Item Name: Wearplate Assembly

Accept

\*N900040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Start Date: 13/04/2012 Start Qty: 5.00 \*5\*  
Required Date: 27/04/2012 Req'd Qty: 5.00 \*5\*  
Reference:

Cust Item ID:  
Customer:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

Identify as per dwg & Stock Location: FP.1

0.00

\*170\*

Packaging

Memo

0.00

Packaging

x2 6 94 11/06/11

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

12/06/2012 JH  
mf 12-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-13-12 1:42:40 PM

Page 1

Work Order ID: 83220

\*83220\*

Parent Item: D4154-041

\*D4154-041\*

Parent Item Name: Wearplate Assembly

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 10.09.21 new issue DD ver:EC  
10.11.04 added DT9684 DD ver:EC  
per dwg revB DD ver:EC

IPP Rev:B  
IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1		Manufactured	No			100	Each	1.0000	1	5			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D4154-1\*

Plate

84746x2

\*\*

12-06-18

JBL

Location

Loc Qty

Loc Code

WA

1

66312

1

D4155-1		Manufactured	No			100	Each	0.0000	1	5			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D4155-1\*

Bar

\*\*

12-06-18

JBL

83846x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

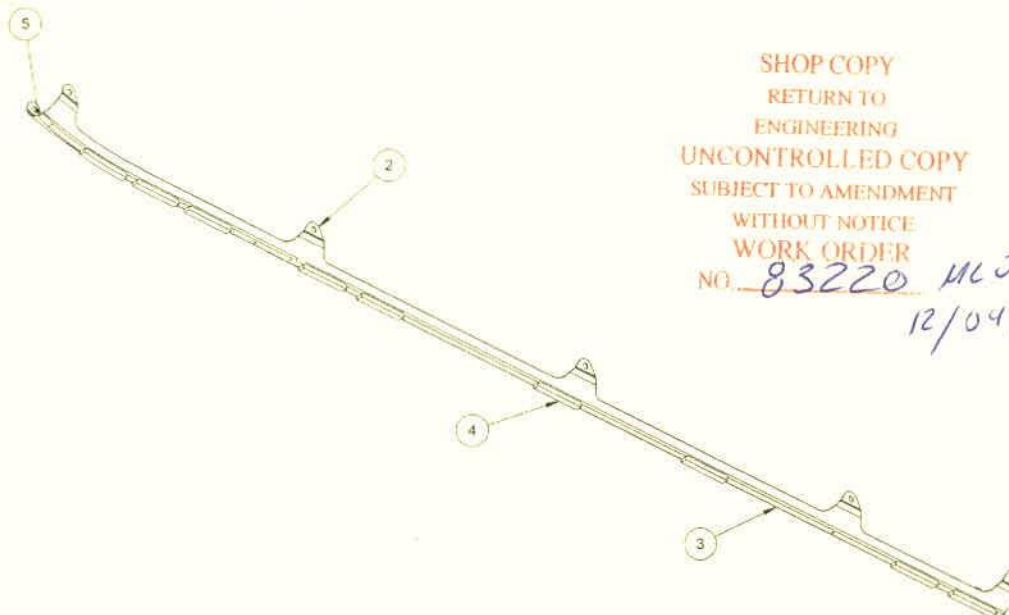
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT 2)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83220 *MLJ*  
*12/04/13*



D4154-041 WEARPLATE ASSEMBLY

RELEASED  
2012-04-11  
*AM*

C	REVISE NOTE 9 (ZN A8-2), ADD HARDCOAT (ZN B7-2), ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1), REMOVED FINISH TO NOTE 2 (A8-2), REMOVED SECTION A-A (NO LONGER REQUIRED), REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. <b>D4154</b>	REV. C
MFG. APPR.	<i>RF</i>	SHEET 1 OF 3	
APPROVED	<i>RF</i>	TITLE <b>WEARPLATE ASSEMBLY</b>	SCALE NTS
DE APPR.	<i>RF</i>	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
DATE	12.02.21	THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE BASIS OF A DETERMINATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

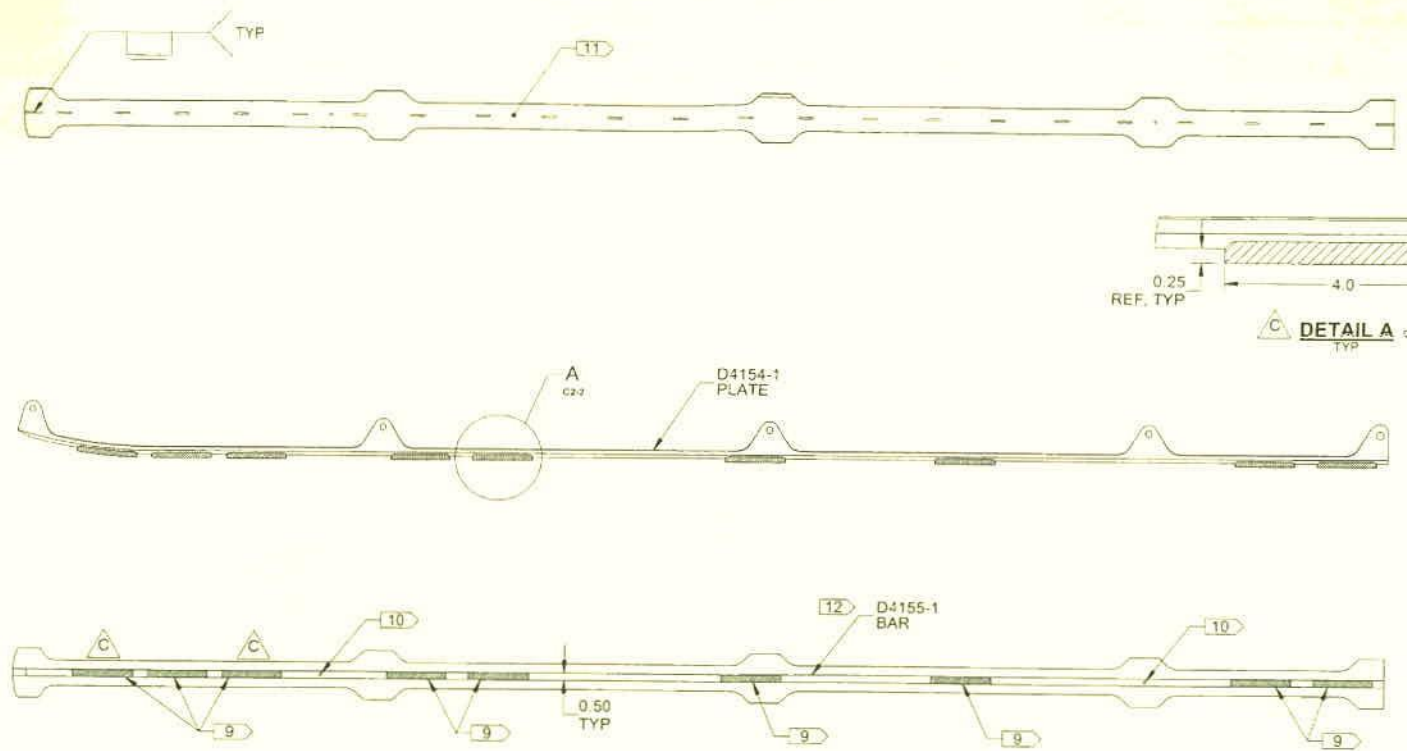
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

83220



**D4154-041 WEARPLATE ASSEMBLY**

RELEASED  
2012-04-11

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
- 10) TRANSFER DRILL  $\varnothing$  0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4154	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

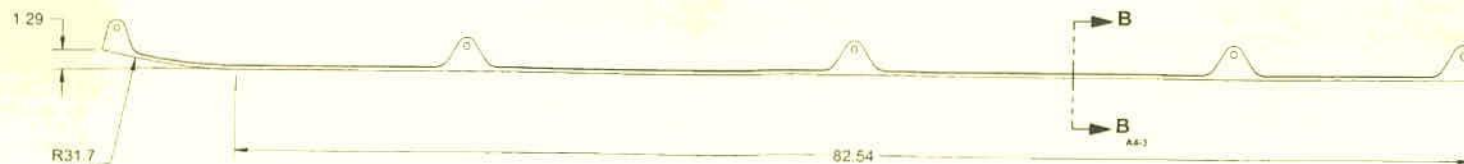
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

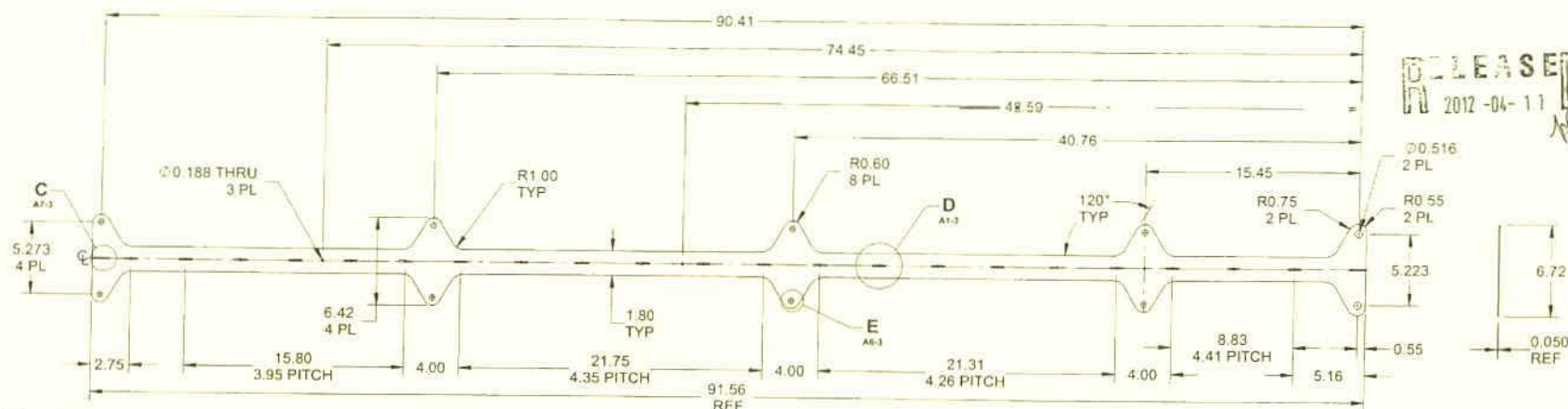
**NOTE:** Date & initial all entries

83220

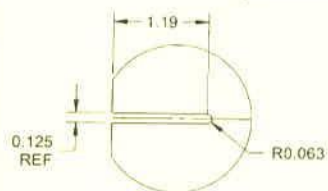
RELEASED  
2012-04-11



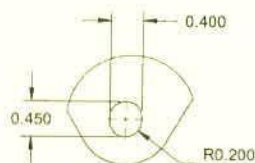
**D4154-1 PLATE**  
(MAKE FROM D4154-1F)



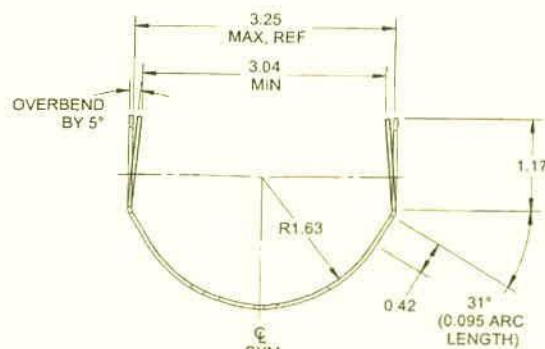
**D4154-1F FLAT PATTERN**



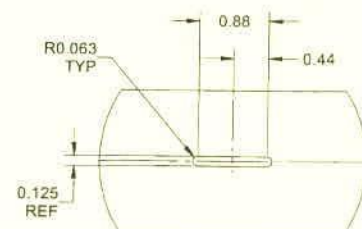
**DETAIL C**  
END SLOT DETAIL, 2 PL



**DETAIL E**  
SLOT DETAIL TYP



**SECTION B-B**



**DETAIL D**  
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
  - 2) FINISH : NONE
  - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION : NONE
  - 7) WEIGHT : 2.95 lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4154	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

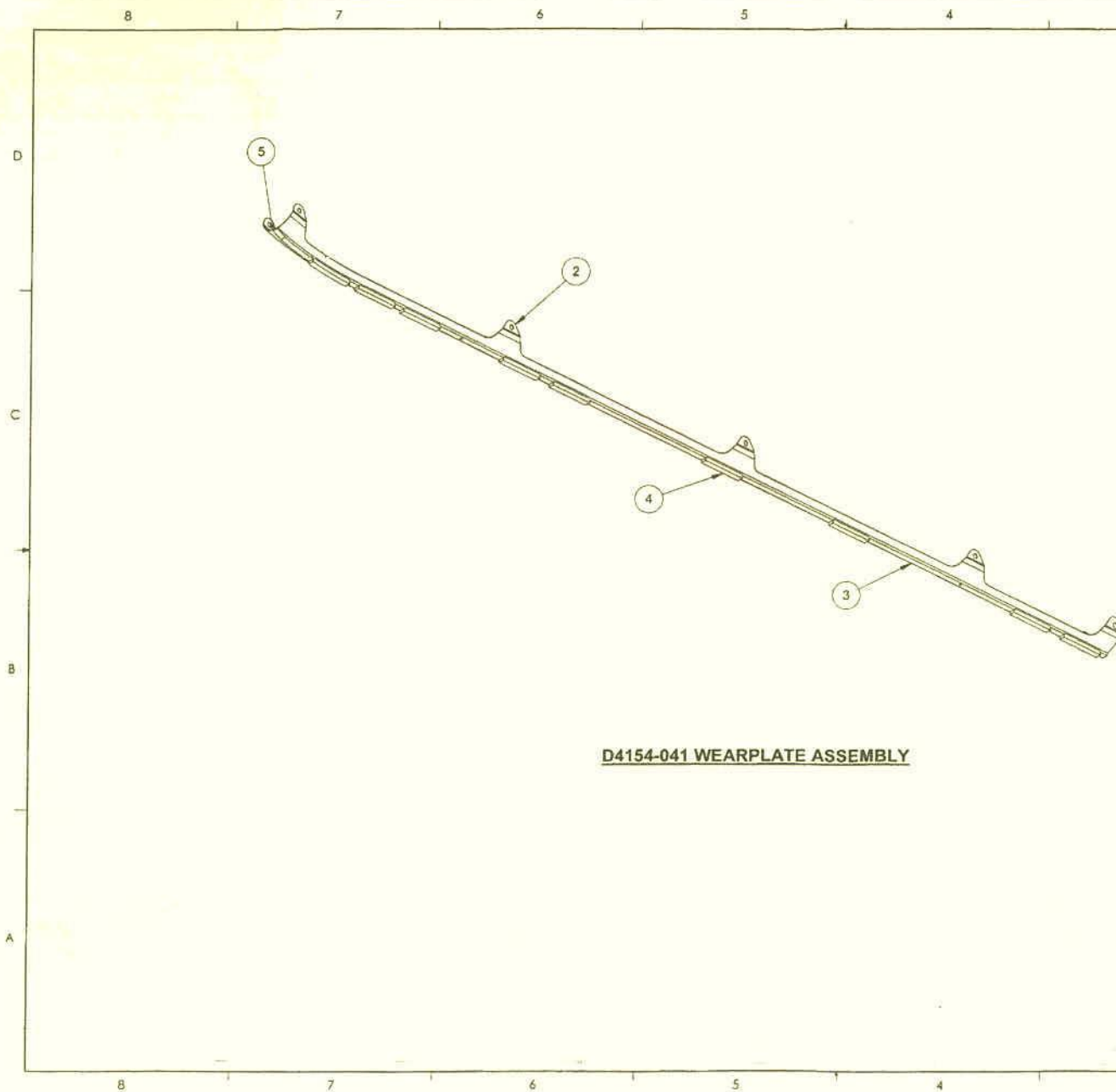
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





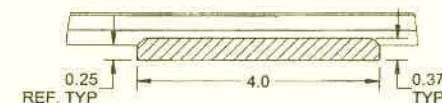
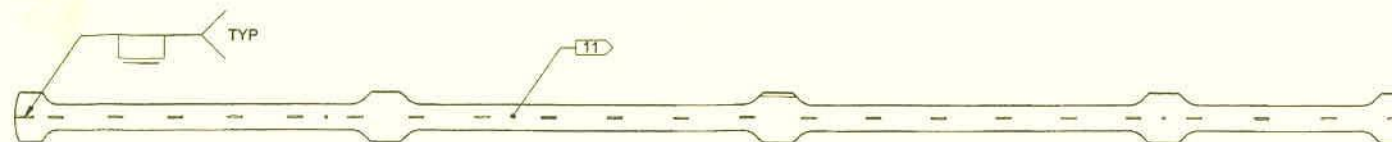
**D4154-041 WEARPLATE ASSEMBLY**

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT 2)

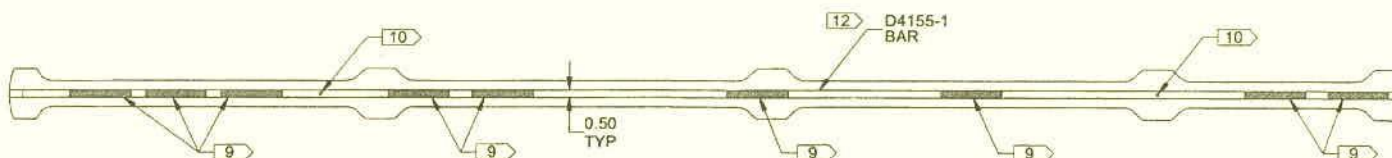
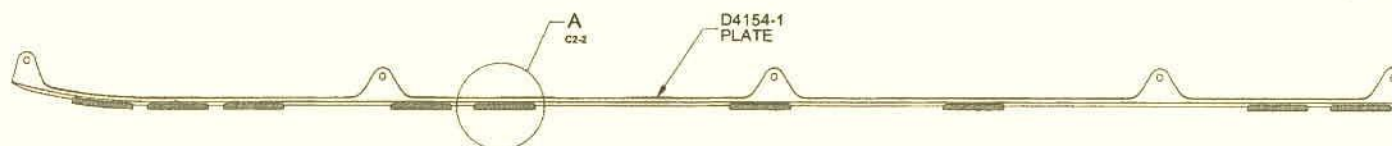
**RELEASED**  
2012-05-09  
MD

REV.	DESCRIPTION	BY	DATE
D	70.45 WAS 74.45 & $\varnothing$ 0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A5-2), ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (C3-1); REMOVED FINISH TO NOTE 2 (A5-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4154	REV. D
MFG. APPR.	RF	TITLE	SHEET 1 OF 3
APPROVED	RF	WEARPLATE ASSEMBLY	SCALE
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**DETAIL A** C5-2  
TYP



**D4154-041 WEARPLATE ASSEMBLY**

**NOTES:**

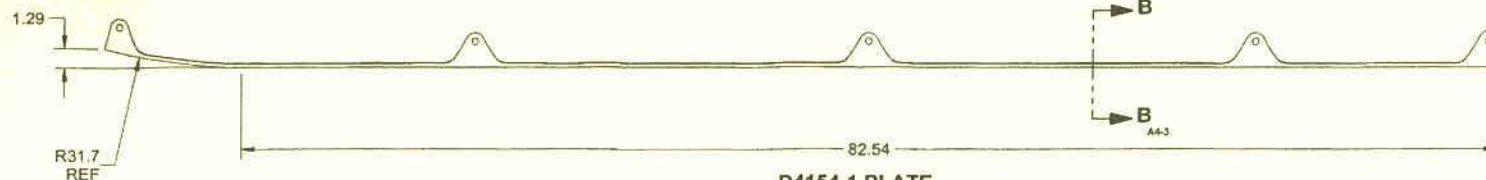
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
- 10) TRANSFER DRILL  $\varnothing$ 0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

**RELEASED**  
2012-05-09  
MP

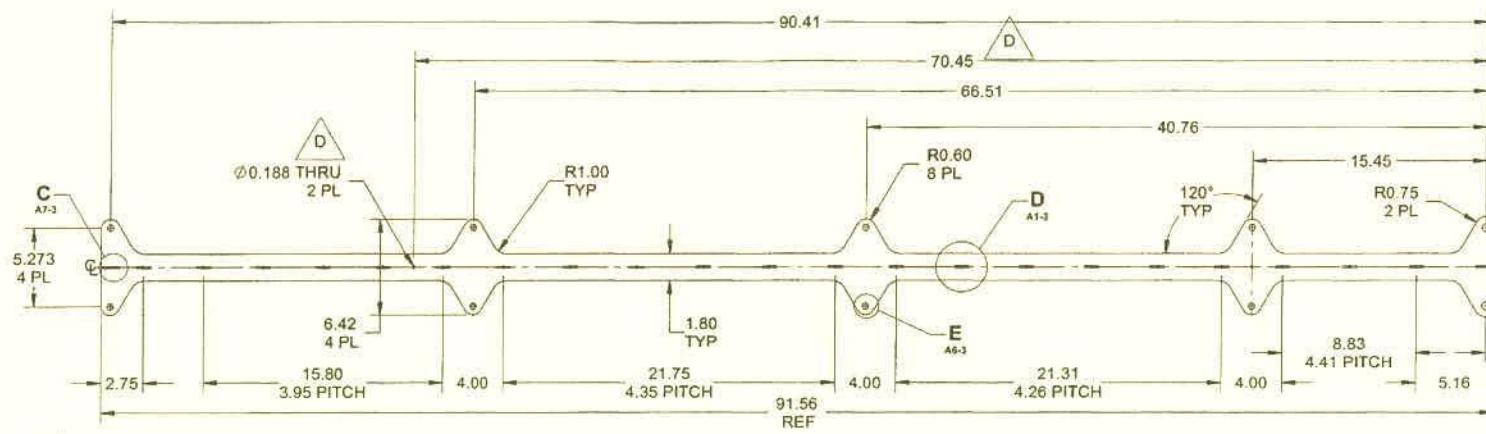
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DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	<b>D4154</b>	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
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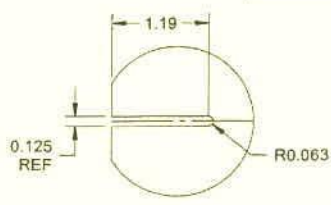




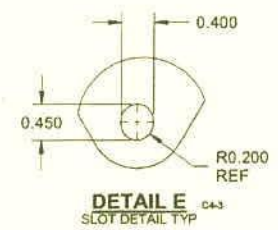
**D4154-1 PLATE**  
(MAKE FROM D4154-1F)



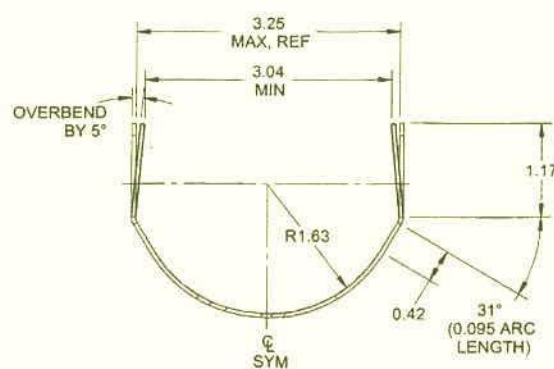
**D4154-1F FLAT PATTERN**



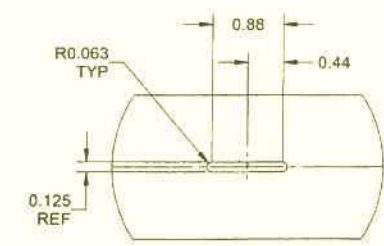
**DETAIL C**  
END SLOT DETAIL, 2 PL



**DETAIL E**  
SLOT DETAIL TYP



**SECTION B-B**



**DETAIL D**  
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
  - 2) FINISH : NONE
  - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION : NONE
  - 7) WEIGHT : 2.95-lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4154</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSEMBLY</b>	NTS
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**RELEASED**  
2012-05-09

NAME		LAST		FIRST		MIDDLE		SUFFIX	
JAMES		HARRIS		JAMES		HARRIS		JAMES	
DATE		TIME		PLACE		REASON		REMARKS	
1965		10:00		NEW YORK		TRAVEL		BUSINESS	

DATE 10/10/65

10/10/65



ALL INFORMATION CONTAINED  
HEREIN IS UNCLASSIFIED  
DATE 10/10/65 BY 1045  
REASON: 1.05

10/10/65

10/10/65

10/10/65

10/10/65



# **ENGINEERING CHANGE NOTICE** **DART AEROSPACE LTD**

Date: 12.05.03	Job No.: RD3403	ADR Yes/No: N	ADR Date: <del>###</del>	ECN #: 12- 582
Product No.: D350-636		Created By: RF	Approved By: <del>###</del>	
Product Name: Skidtube Installations		Checked By: <del>###</del>		

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LE/MP	
Purchasing Coord.	Y	CL	
Production Engineering Coord.	Y	EC/DD	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	N		
QC Coordinator	N		
Customer Technical Support	N		
Marketing	N		
Customer Order Processing	N		

**Reason for Change:** Revise D4154 per Production feedback.  
Product Improvement

**Documents Affected:**  
D4154 Rev. D

**PARTS MUST COMPLY**



**PREVIOUS PARTS SATISFACTORY**



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	N		UPDATE MDL NEXT UPDATE	
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.05.09 <del>###</del>
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.05.09 <del>###</del>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update PPP's	N			
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N	<del>MP</del>		
22	Update Grey Project / Electronic Binder PDF Files	N	<del>MP</del>		
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.05.09 <del>###</del>
24					

**Description / Action:**  
Update BOM/routing for D4154 Rev. D  
D4154-1F Flat Pattern per Rev. C can be rework by plugging the holes while making D4154-041 and transfer the holes using drawing D4154 Rev. D  
Update D4154 water jet program per D4154 Rev. D dxf.

sth -13 X04654-1      5 - 83220  
 1-66312      5 - 83219  
 12-83217      8 - 83693

ECN Verified & Complete: \_\_\_\_\_ Date: \_\_\_\_\_

